

# Work Order ID 86767

July-06-12 2:37:32 PM

**\*86767\***

Page 1

Item ID: D2332-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Lid Prop Assembly 6.69" long  
 Start Date: 7/06/12 Start Qty: 6.00 **\*6\*** Cust Item ID:  
 Required Date: 8/03/12 Req'd Qty: 6.00 **\*6\*** Customer:  
 Reference:

Approvals: Process Plan: *P* Date: 12-07-9 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2332	Rev C1								

100

0.00

**\*100\***

Small Fab

Small Fab

Memo

0.00

1- Cut D2332-7 and D2332-5 to length as per dwg D2332.

2- Cut D2332-11 using 1/2" S.S tubing 7.735" long.

3- Deburr.

0.00

110

**\*110\***

Brake NC

Brake NC

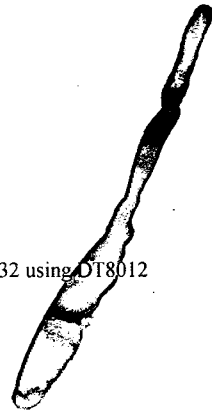
Memo

0.00

Punch and form D2332-11 to length as per dwg D2332 using DT8012  
 ( need 2 per ass'y)

6 Ø FF 12-09-05

6 Ø FF 12-09-05



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 86767

**\*86767\***

Page 2

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Item ID: D2332-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Lid Prop Assembly 6.69" long

Start Date: 7/06/12 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 8/03/12 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start **\*NR1\***






QC: Date: SPC (Y/N): Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
<b>*120*</b>						6	0		FF 12-08-05
Small Fab	Memo	0.00							
Small Fab	1- Drill hole in D2332-11 as per dwg D2332 using drill jig DT8459 (drill one per ass'y)								
	2- Ensure no foreign objects inside tube								
	3- Deburr								
130	QC5- Inspect part completeness to step on W/O	0.00				6			FB 12-9-10
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									
140		0.00				6			EL 12-9-10
<b>*140*</b>									
Large Fab	Memo	0.00							
Large Fab	Weld D2332-11 and D2332-5 as per dwg (weld 1 per ass'y) *****ensure nothing is inside of tube before welding*****								
	S.S Rod batch: M 182 357								

W/O: 86767		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2332-041 PAR #: \_\_\_\_\_ Fault Category: Sm Tab NCR: Yes No DQA: fwf Date: 12/09/18  
 Resolution: \_\_\_\_\_ Disposition: Scrap QA: N/C Closed: ck Date: 12/9/20

NCR: 121817		WORK ORDER NON-CONFORMANCE (NCR) <u>87.5t</u>						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/09/10	±	Round drill bit with the 1/4" hole drilled in a angle to the punches. Eng. R-6 not <del>drilled</del> correctly	 Q57042 12/09/10	Scrap + Daily drill bit M 121848	FF 12-09-10	 17/09/10	 Q57042 12/09/10	 Q57042 12/09/10
		in sig. Part made in sig RC Tooling.		Have sig. & machine in place to prevent punches end from twisting	FF 12-09-10	 17/09/10		

NOTE: Date &amp; initial all entries

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**\*86767\***

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Item ID: D2332-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Lid Prop Assembly 6.69" long

Start Date: 7/06/12

Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 8/03/12

Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 <b>*150*</b> QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds  Memo	0.00 0.00	(DAS 24 9-09)	12-9-11		6X			
160 <b>*160*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00	Smb	12-9-11	(DAS 16 9-09)	6			
170 <b>*170*</b> Small Fab Small Fab	1- Tumble 2- Assemble as per dwg D2332	0.00 0.00				6	26	12-9-12	FF 12-09-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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 Required Date: 8/03/12 Req'd Qty: 6.00 **\*6\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 <b>*180*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 Smb 12-9-13	DAF 16 12/16/13			6			
190 <b>*190*</b> Packaging Packaging	Identify as per dwg & Stock Location: <u>ST255</u>  Memo	0.00 0.00				6x		80 12-9-14	
200 <b>*200*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00						12/9/17 MF 12-09-11	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Page 1

Work Order ID: 86767

Parent Item: D2332-041

Parent Item Name: Lid Prop Assembly 6.69" long

Start Date: 7/06/12

Required Date: 8/03/12

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B02.08.12Re-format; Incorporated D2332-13/-11/-7/-5KJ/RF

IPP Rev:C 08-06-02 add comment DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-4A Bolt		Purchased	No			170	Each	50.0000	1	6			

Location Loc Qty Loc Code

FP001 122416 6  
114615 6  
ST355 44  
120187 31  
121285 13

6 (6) FF 12-09-13

AN960JD416L  
Washer

NAS1149D0416J

Purchased

No

170 Each 6.0000

3 18

(6) FF 12-09-13

Location Loc Qty Loc Code

FP002 122441 6  
110153 6

18

M304R.250  
304 SS Round bar .250

Purchased

No

100 f 13.4970

0.1 0.6315792

(6) FF 12-09-05

Location Loc Qty Loc Code

MAT028 13.497  
114482 2.55  
120243 10.947

0.6315

M304TR0.500W.035  
304 RD Tube .500 x .035W

Purchased

No

110 f 299.2032

1.25 7.894737

(6) FF 12-09-05

Location Loc Qty Loc Code

MAT017 299.2031723  
115535 0.913  
116720 1.66068  
117598 7.6415923  
119160 4.79  
119644 2.1209  
120633 82.077  
121848 200

7.8947

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

July-06-12 2:37:31 PM

Page 2

Work Order ID: 86767

Parent Item: D2332-041

Parent Item Name: Lid Prop Assembly 6.69" long

Start Date: 7/06/12

Required Date: 8/03/12

Start Qty: 6.00

Required Qty: 6.00

M304TR1.000W.049  
304 RD Tube 1.00 x .049W

Purchased No

100 f 49.4700 0.43 2.7157896

⑥ FF 12-09-08

Location

Loc Qty

Loc Code

MAT018

49.470015

117598

0.000015

120654

49.47

2.7157

MS21042L4

Purchased No

170 Each 1,449.0000

1

6

⑥ FF 12-09-13

Nut

Location

Loc Qty

Loc Code

ST300

1449

119075

116

121011

193

121444

840

121652

300

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector






Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

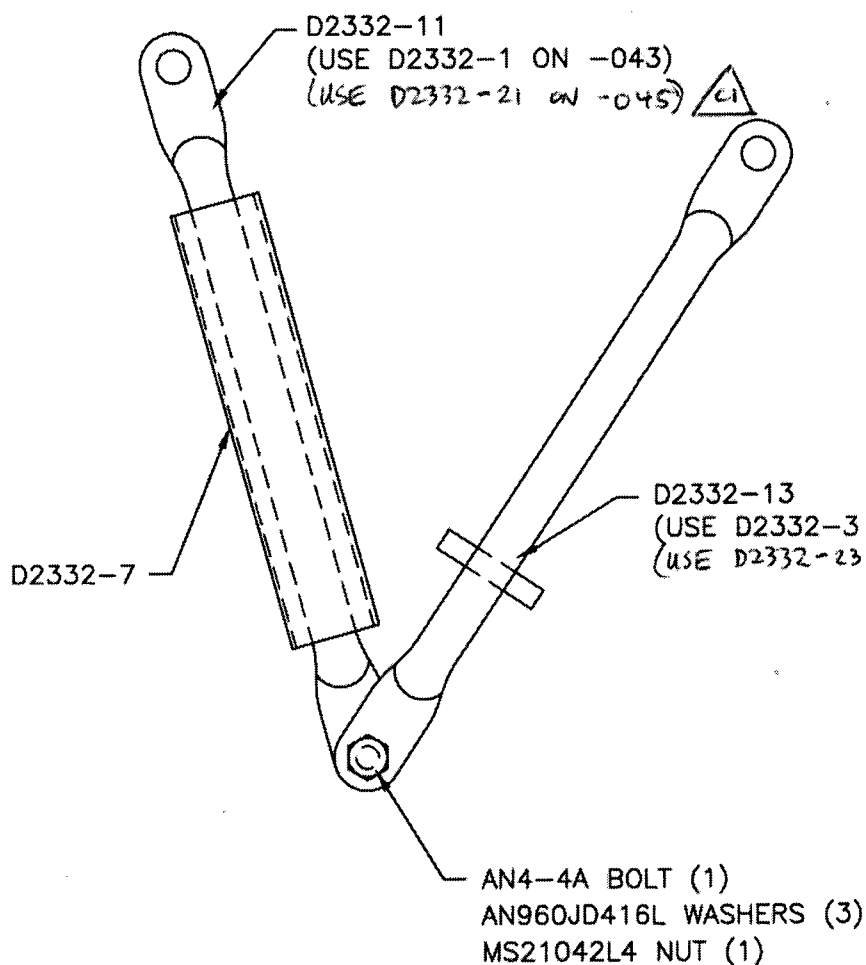
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
CHECKED 	APPROVED 	DRAWING NO. D2332	REV. C SHEET 1 OF 2		
DATE 03.07.03		TITLE LOD PROP ASSEMBLY	SCALE NTS		
A	94.12.16	NEW ISSUE			
B	97.09.30	CHANGE 416 WASHERS TO 416L			
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)			
C1 	03.08.06	ADD -045 PROP (7.25" LONG)			

RELEASED  
03.07.04 *[Signature]*



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *86767*

*PLD-07-9*

D2332-041 SHOWN  
(D2332-043 SIMILAR)  
(D2332-045 SIMILAR) *[Triangle symbol with C1]*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

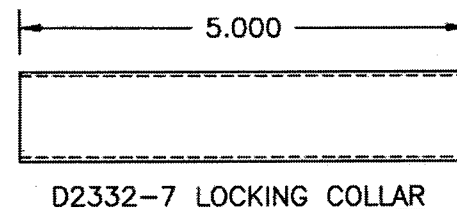
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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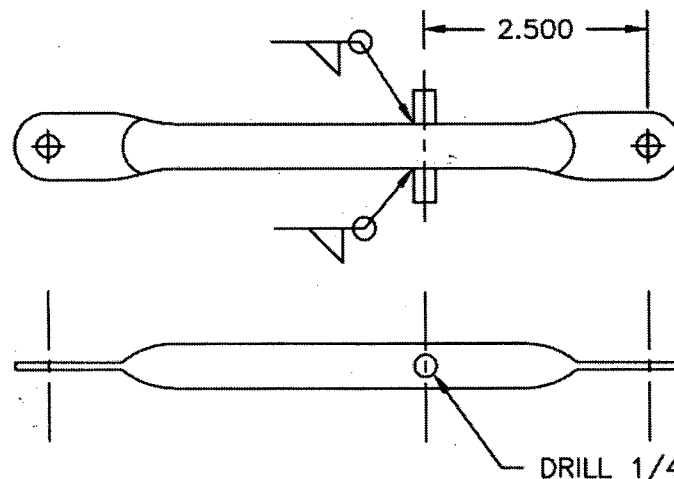
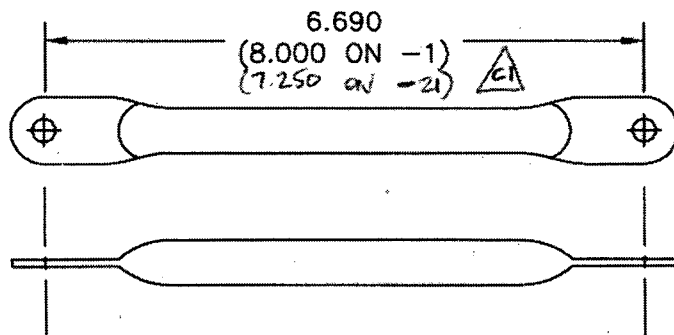
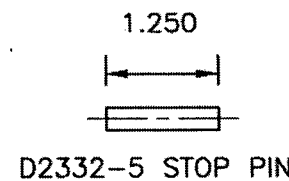
**DART**



DESIGN	DRAWN BY	DART AEROSPACE LTD
#	#	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
#	#	D2332
DATE	TITLE	REV. C
03.07.03	LID PROP ASSEMBLY	SHEET 2 OF 2
		SCALE 1:2
C	03.07.03	MAKE - 041 PROP 6.69" LONG (END)
C1	03.08.06	MAKE - 043 PROP 8.00" LONG (INT)
		ADD - 045 PROP 7.25" LONG



96767



D2332-13  
M/F D2332-11 & D2332-5  
(D2332-3 SIMILAR - M/F D2332-1 & D2332-5)  
(D2332-23 SIMILAR - M/F D2332-21 & D2332-5)

NOTES:

- MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035  
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250  
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
- TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

RELEASED  
03.07.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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